

I CLAIM:

1. A modular spa comprising:
a spa shell including at least one support member integrally molded therewith; and
a support frame supporting the spa shell at the at least one support member.
2. The modular spa according to claim 1, wherein the support frame comprises a plurality of elongate polymeric support struts, and the support struts are secured to the support members.
3. The modular spa according to claim 1, wherein the spa shell comprises a bottom and a side together defining a fluid support surface, and the support member is integrally molded with the side.
4. The modular spa according to claim 3, wherein the side comprises a substantially upright side wall and a rim extending from and surrounding the side wall, and the support member is integrally molded with the rim.
5. The modular spa according to claim 4, wherein the rim is integrally molded with the side wall.
6. The modular spa according to claim 4, wherein the support member includes a substantially horizontal top surface, and a substantially vertical outer surface, and the rim includes a rim top extending substantially horizontally and outwards from the side wall over the top surface, and a rim face extending substantially downwards from the rim top and over the outer surface, the rim face being distinct from the side wall, the rim top and the rim face substantially surrounding the support member.

7. The modular spa according to claim 6, wherein the support member is integrally molded with the rim top and the rim face.
8. The modular spa according to claim 6, wherein the vertical outer surface of the support member includes a first substantially vertical support surface, and a flange extending outwardly from the first support surface, and the rim face includes a first substantially vertical face disposed over the first support surface, and a lip extending substantially outwards from the first vertical face and surrounding the flange.
9. The modular spa according to claim 8, wherein the flange is integrally molded with the lip.
10. The modular spa according to claim 9, wherein the lip is integrally molded with the rim face, and the rim face is integrally molded with the rim top.
11. A spa shell comprising:
 - a bottom and a side together defining a fluid support surface ; and
 - a support member integrally molded with the side.
12. The spa shell according to claim 11, wherein the side comprises a substantially upright side wall and a rim extending from and surrounding the side wall, and the support member is integrally molded with the rim.
13. The spa shell according to claim 12, wherein the rim is integrally molded with the side wall.
14. The spa shell according to claim 12, wherein the support member includes a substantially horizontal top surface, and a substantially vertical outer surface, and the rim includes a rim top extending substantially horizontally and outwards from the side wall over the top surface, and a rim face extending substantially

downwards from the rim top and over the outer surface, the rim face being distinct from the side wall, the rim top and the rim face substantially surrounding the support member.

15. The spa shell according to claim 14, wherein the support member is integrally molded with the rim top and the rim face.

16. The spa shell according to claim 14, wherein the vertical outer surface of the support member includes a first substantially vertical support surface, and a flange extending outwardly from the first support surface, and the rim face includes a first substantially vertical face disposed over the first support surface, and a lip extending substantially outwards from the first vertical face and surrounding the flange.

17. The spa shell according to claim 16, wherein the flange is integrally molded with the lip.

18. The spa shell according to claim 16, wherein the lip is integrally molded with the rim face, and the rim face is integrally molded with the rim top.

19. The spa shell according to claim 11, wherein the support member comprises one of a metal extrusion and a polymeric extrusion, and the side comprises a polymeric sheet molded around a portion of the extrusion.

20. The spa shell according to claim 19, wherein the polymeric sheet includes an acrylic layer, and an ABS plastic layer bonded to the acrylic layer, and the support member is disposed within the ABS plastic layer.

21. The spa shell according to claim 11, wherein the bottom is integrally molded with the side.

22. The spa shell according to claim 14, wherein the rim face includes at least one of a permanent magnet and a metal strip for removably securing a cabinet to the spa shell.

23. A method of fabricating a spa shell comprising the steps of:
disposing a support member in a spa mold, the spa mold defining a shape of a spa shell;

with the mold, molding a polymeric layer around the support member, the polymeric layer adopting the shape of the spa shell, the support member being integrally molded with the polymeric layer; and

releasing the polymeric layer and the support member from the mold.

24. The method according to claim 23, wherein the molding step comprises the steps of heating the polymeric layer until pliable, and vacuum forming the pliable polymeric layer to the shape of the spa shell and over the support member.

25. The method according to claim 24, wherein the releasing step comprises the steps of allowing the polymeric layer to cool sufficiently to retain the shape of the spa shell, and removing the cooled spa shell from the mold, the spa shell comprises a bottom and a side together defining a fluid support surface, and the support member is integrally molded with the side.

26. The method according to claim 25, wherein the side comprises a substantially upright side wall and a rim extending from and surrounding the side wall, and the support member is integrally molded with the rim.

27. A spa kit comprising:

a spa shell comprising a polymeric sheet molded in the shape of a spa and including at least one support member integrally molded the molded polymeric sheet;

a support frame for supporting the spa shell at the at least one support member; and

a spa base for supporting the support frame.

28. The spa kit according to claim 27, wherein the support frame comprises a plurality of elongate polymeric support struts, and the support struts are secured to the support members.

29. The spa kit according to claim 27, wherein the spa shell comprises a bottom and a side together defining a fluid support surface, and the support member is integrally molded with the side.

30. The spa kit according to claim 29, wherein the side comprises a substantially upright side wall and a rim extending from and surrounding the side wall, and the support member is integrally molded with the rim.

31. The spa kit according to claim 30, wherein the rim is integrally molded with the side wall.

32. The spa kit according to claim 30, wherein the support member includes a substantially horizontal top surface, and a substantially vertical outer surface, and the rim includes a rim top extending substantially horizontally and outwards from the side wall over the top surface, and a rim face extending substantially downwards from the rim top and over the outer surface, the rim face being distinct from the side wall, the rim top and the rim face substantially surrounding the support member.

33. The spa kit according to claim 32, wherein the support member is integrally molded with the rim top and the rim face.

34. The spa kit according to claim 32, wherein the vertical outer surface of the support member includes a first substantially vertical support surface, and a flange extending outwardly from the first support surface, and the rim face includes a first substantially vertical face disposed over the first support surface, and a lip extending substantially outwards from the first vertical face and surrounding the flange.

35. The spa kit according to claim 34, wherein the flange is integrally molded with the lip.

36. The spa kit according to claim 35, wherein the lip is integrally molded with the rim face, and the rim face is integrally molded with the rim top.

37. The spa kit according to claim 35, further including a cabinet for attachment to the spa shell and the spa base.

38. The spa kit according to claim 37, wherein the cabinet comprises a plurality of decorative panels.

39. The spa kit according to claim 37, wherein the cabinet is configured for attachment at one end to the second vertical face below the lip, and for attachment at an opposite end to the spa base.

40. The spa kit according to claim 37, further including a cabinet for attachment to the spa shell and the spa base, and one of the support frame and the spa shell includes a first permanent magnet for removably securing the cabinet thereto.

41. The spa kit according to claim 40, wherein the spa base includes at least one of a second permanent magnet for removably securing the cabinet to the spa base.

42. The spa kit according to claim 38, wherein the spa base comprises a plurality of interlockable base sections.

43. The spa kit according to claim 29, wherein the support member comprises one of a metal extrusion and a polymeric extrusion, and the side comprises a polymeric sheet molded around a portion of the extrusion.

44. The spa kit according to claim 43, wherein the polymeric sheet includes an acrylic layer, and an ABS plastic layer bonded to the acrylic layer, and the support member is disposed within the ABS plastic layer.

45. The spa kit according to claim 44, wherein the bottom is integrally molded with the side.

46. A method of assembling a modular spa comprising the steps of:
 providing a prefabricated spa shell, the spa shell comprising a polymeric sheet molded in the shape of a spa and including at least one support member integrally molded the molded polymeric sheet;
 providing a spa base, and securing a support frame at one end to the at least one support member of the spa shell and at an opposite end to the spa base; and
 securing a cabinet to the spa shell and to the spa base.